

Work Order ID 116674

April-23-14 9:15:38 AM

D4541-6

~~D4541-6~~ 116674

\*116674\*

Page 1

Item ID: D4541-6

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket,RH

Start Date: 4/23/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/07/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-04-23

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4541	E
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100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

0.00

1- Cut as per dwg (CUT D4541-5F)

Prog rev: P

Dwg rev: P

2- Deburr

10 0 Jim 4-05-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

10 0 Jim 4-05-11

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Page 2

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:****Start Qty:** 10.00**Req'd Qty: 10.00**

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC8- Inspect parts - second check

0.00 27  
9.89  
0.00 415/13

**\*120\***

QC

## Memo

## Quality Control

0.00

**\*125\***

### Small Fab

## Memo

## Small Fab

BEND TABS PER DWG

0.00

**DAS  
30  
9-89**

QC5- Inspect part completeness to step on W/O

0.00

**\*127\***

QC

## Memo

## Quality Control

0.00 DAS  
27  
9-89  
14/5/13

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**\*116674\***

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Item ID: D4541-6 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket,RH  
Start Date: 4/23/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 5/07/14 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				10	VB14520		
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00				10			
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>SI525</u>	0.00				10X			
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									

DAS  
27  
9-89

14/5/20

DAS  
28  
9-89

MAY 20 2014

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Item ID: D4541-6 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Bracket,RH  
Start Date: 4/23/14 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 5/07/14 Req'd Qty: 10.00 \*10\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

14/5/21

MF  
14-5-21

# Picklist Print

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Page 1

Work Order ID: 116674

**\*116674\***

Parent Item: D4541-6

**\*D4541-6\***

Parent Item Name: Bracket,RH

Start Date: 4/23/14

Required Date: 5/07/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.05.08 as per dwg revC DD verf:EC IPP  
REV:B 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

249.7232

0.3606

4

**\*M6061T6S 032\***

**\*\***

Jm14-05-11

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

249.72317

123483

8.57

m125822

17

m127272

119.43317

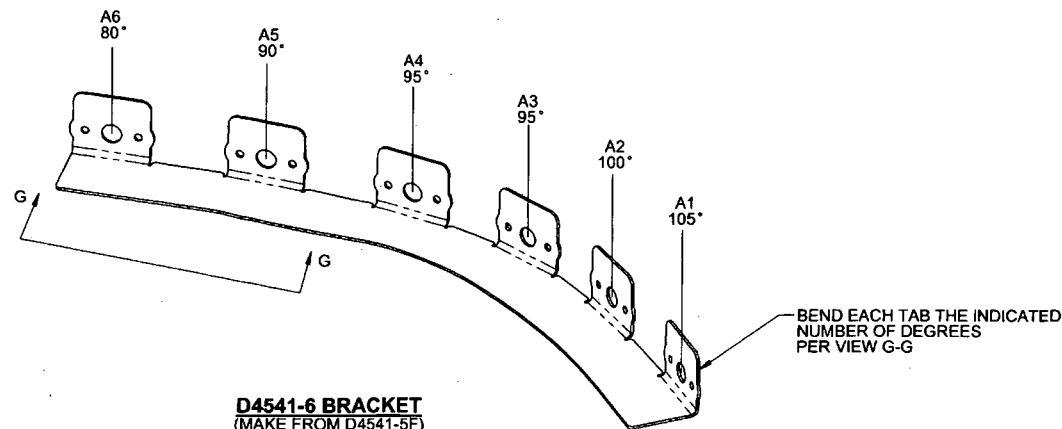
m128054

104.72

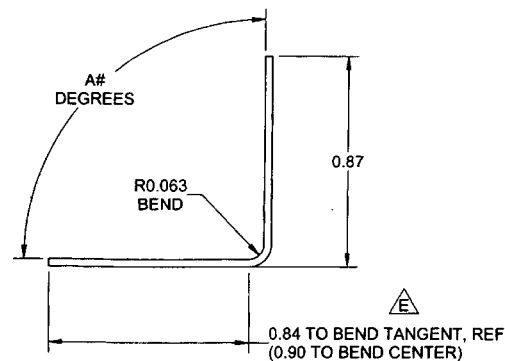
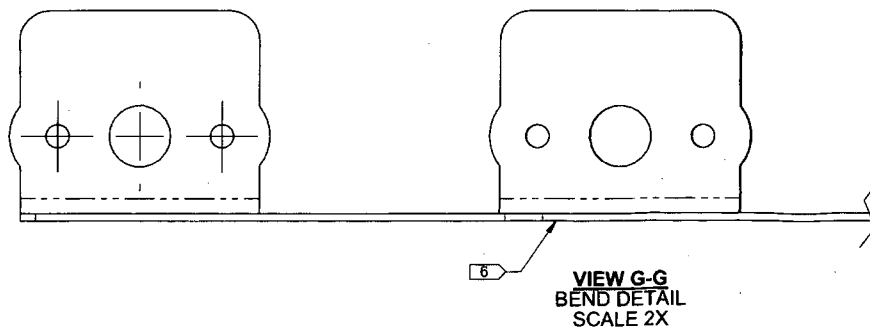
128054.



116674 MLS  
1404-23

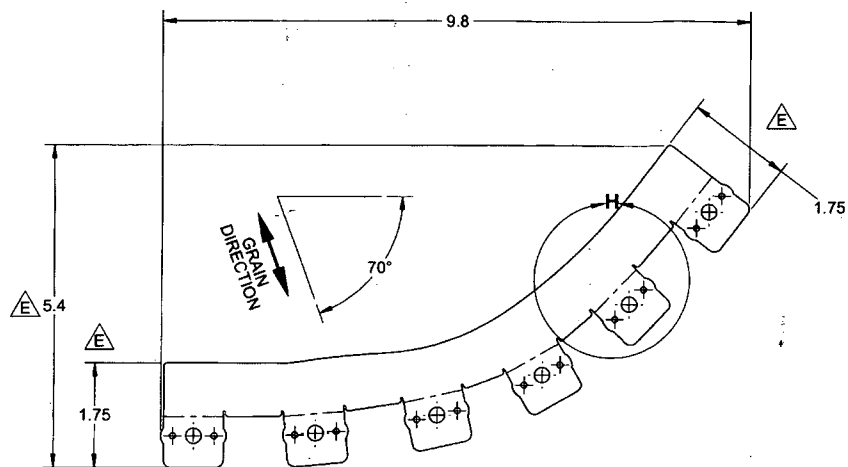


**D4541-6 BRACKET**  
(MAKE FROM D4541-5F)

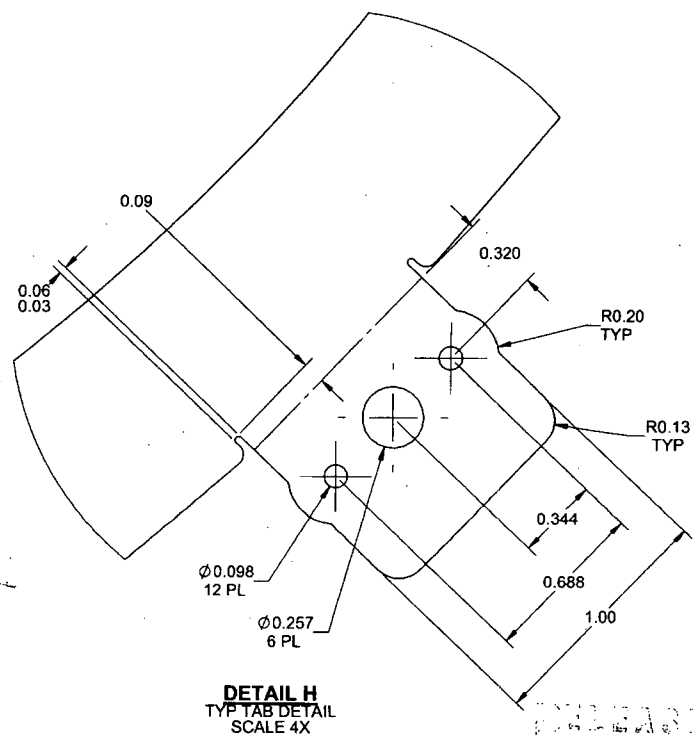


- NOTES:**
- 1) MATERIAL: MAKE FROM D4541-5F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 0.04 lbs

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D4541</b>	SHEET 9 OF 13
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
DATE	14.03.07	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4541-5F FLAT PATTERN**



**DETAIL H**  
TYP TAB DETAIL  
SCALE 4X

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-5F-REVE.DXF"

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4541	SHEET 10 OF 13
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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